

Work Order ID 53589-1 *Split*

November 9, 2009 11:22:17 AM



Page 1

Item ID: D3709-1

Accept



Setup Start



Revision ID: A

Item Name: Angle

Stop



Start Date: 09/11/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: *PL*

Date: *11-9*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3709 | Rev A | | | | | | | | |

100



Waterjet

FLOW WATER JET

0.00

Memo

0.00

1-Cut as per Dwg D3709 ☒ Dwg Rev: *A* ☐ Prog Rev: *A*

☐

****grain direction on a 45 degree ****
necessary

☐ 2- Debur if

HB 9-11-11

(6)

110



QC

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

HB 9-11-11

Quality Control

120



QC

QC8- Inspect parts - second check

0.00

Memo

0.00

Quality Control

6 *9-11-11*

Work Order ID 53589

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Page 2

Item ID: D3709-1

Revision ID: A

Item Name: Angle

Start Date: 09/11/2009 Start Qty: 2.00

Required Date: 13/11/2009 Req'd Qty: 2.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

Form as per dwg D3709

0.00

0.00

JB 10/02/26

3

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

8/06/01

3

50



HandFinish

and Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

BR 10-3-1

3

Work Order ID 53589

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Page 3

Item ID: D3709-1

Revision ID: A

Item Name: Angle

Start Date: 09/11/2009 Start Qty: 2.00

Required Date: 13/11/2009 Req'd Qty: 2.00

Reference:

Accept



Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

QC

Quality Control

Memo

0.00

rel 10/03/01

(X3)

Ø

170

Identify as per dwg & Stock Location:

0.00

Packaging

Memo

0.00

R 10/3/01 (3)

180

QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

10/03/02

MF 10-3-1

Print

November 9, 2009 11:22:21 AM

Page 1

Work Order ID: 53589

Parent Item: D3709-1RevA

Parent Item Name: Angle

Comments:

Start Date: 09/11/2009

Required Date: 13/11/2009

Start Qty: 2.00

Required Qty: 2.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|

M6061T6S.063

Purchased

No

sf

216.0499

0.5600

3



18 9-11-11

6061-T6 .063 Sheet

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

MAT

216.0499211

110551

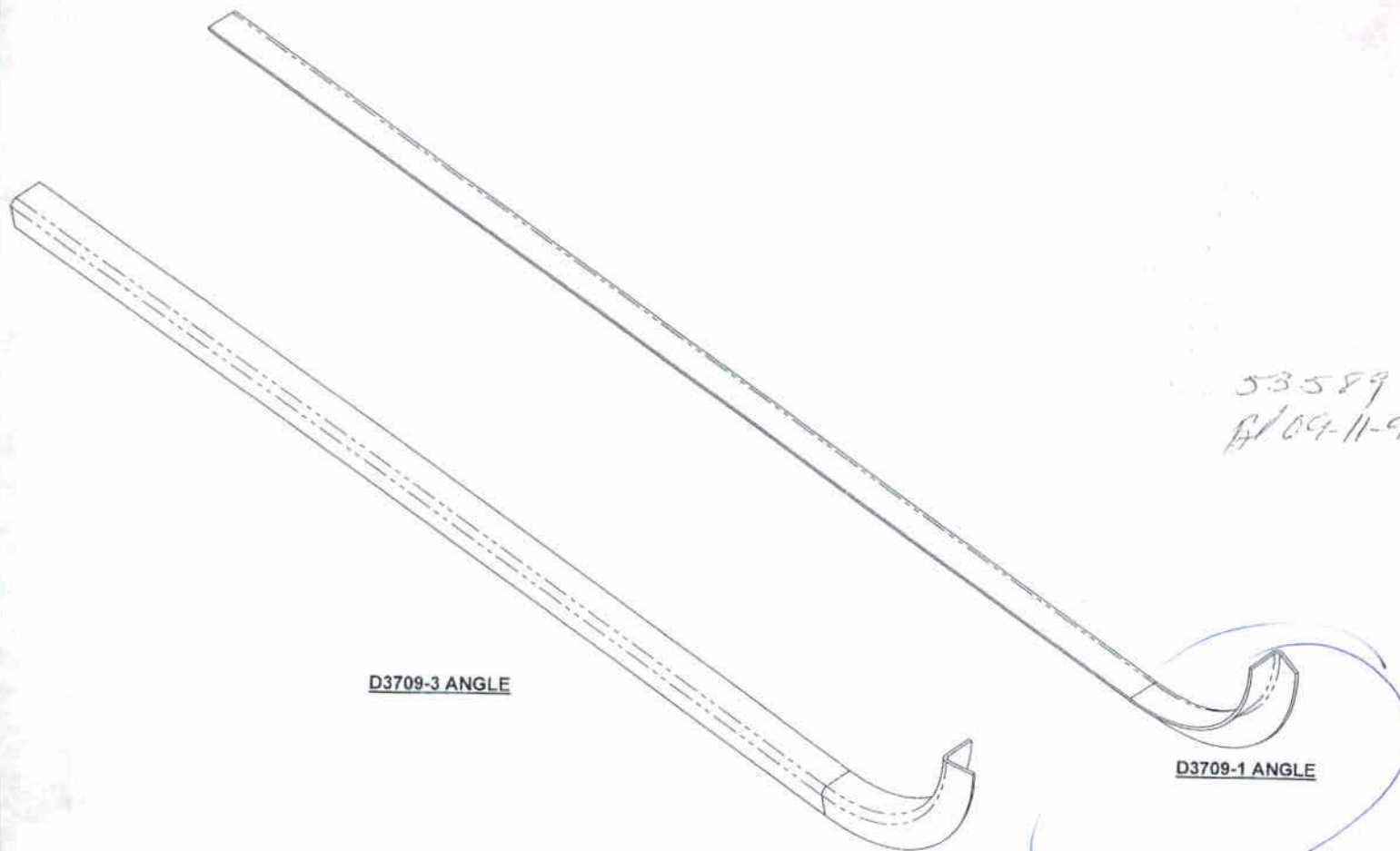
32.0341211

112939

184.0158

112939

6



53589
6/09-11-9

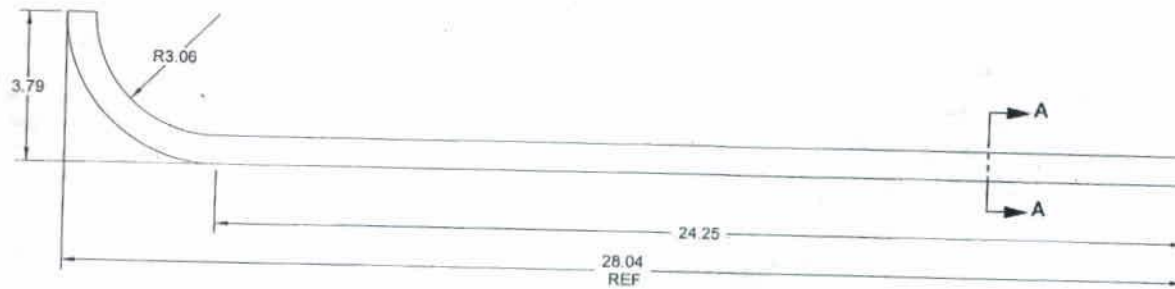
D3709-3 ANGLE

D3709-1 ANGLE

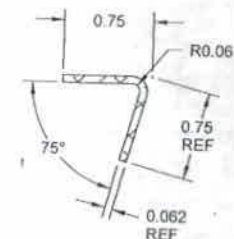
RELEASED
02/18/1974

- NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.063)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3709-X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: D3709-1 = 0.24 lbs
D3709-3 = 0.16 lbs

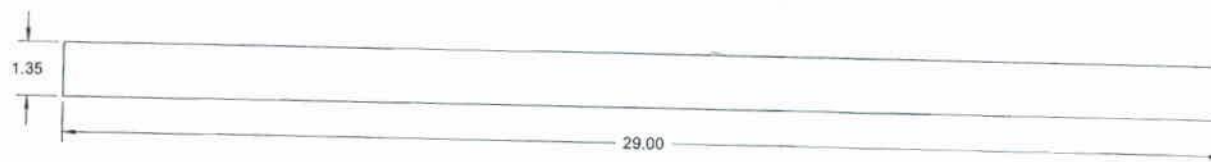
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|------------|-----------|--|--------------|----------|
| REV. | NEW ISSUE | DESCRIPTION | MB | 08.05.02 |
| DESIGN | | | BY | DATE |
| DRAWN | | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | |
| CHECKED | | DRAWING NO. | REV. A | |
| MFG. APPR. | | D3709 | SHEET 1 OF 3 | |
| APPROVED | | TITLE | SCALE | |
| DE APPR. | | ANGLE | NTS | |
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D3709-1 ANGLE
(MAKE FROM D3709-1F)



SECTION A-A
SCALE 2X



D3709-1F ANGLE FLAT PATTERN

RELEASED
09/04/09

| | | | |
|------------|----------|--|--------------|
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| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D3709 | SHEET 2 OF 3 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | ANGLE | NTS |
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